

Date: Wednesday, 6/6/2007 1:43:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG			
Job Number	: 32761						
Estimate Number	: 10008						
P.O. Number	: N/A		Part Number	: D2591			
This Issue	: 6/6/2007	S.O. No.	: N/A		Drawing Number	: D2591 REV D	
Prsht Rev.	: NC		Project Number	: N/A			
First Issue	: N/A		Drawing Revision	: D			
Previous Run	: 31737		Material	: N/A			
Written By	: <u>10</u>		Due Date	: 6/22/2007			
Checked & Approved By	: <u>07.06.07</u>		Qty:	30	Um: Each		
Comment	: Est Rev:I Removed from 9 Digit 05-10-25 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"			
Comment: Qty.: 0.2340 f(s)/Unit Total : 7.0200 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: <u>104288</u> <u>BG 07.06.23</u> 30					
2.0	BAND SAW	BAND SAW			
Comment: BAND SAW Cut blanks: 2.700" long <u>BG 07.06.23</u> 30					
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1			
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 2-Deburr if required <u>BG 07.06.23</u> 30					
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>BG 07.06.23</u> 30					
5.0	QC8	SECOND CHECK			
Comment: SECOND CHECK <u>2007/06/24</u> 30					
6.0	PACKAGING 1	PACKAGING RESOURCE #1			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ <u>EJ 07/06/25</u> (30)					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 32761

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Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

1-207106125

Job Completion



U 87.06.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32761
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BSG
Date:	07-06-23

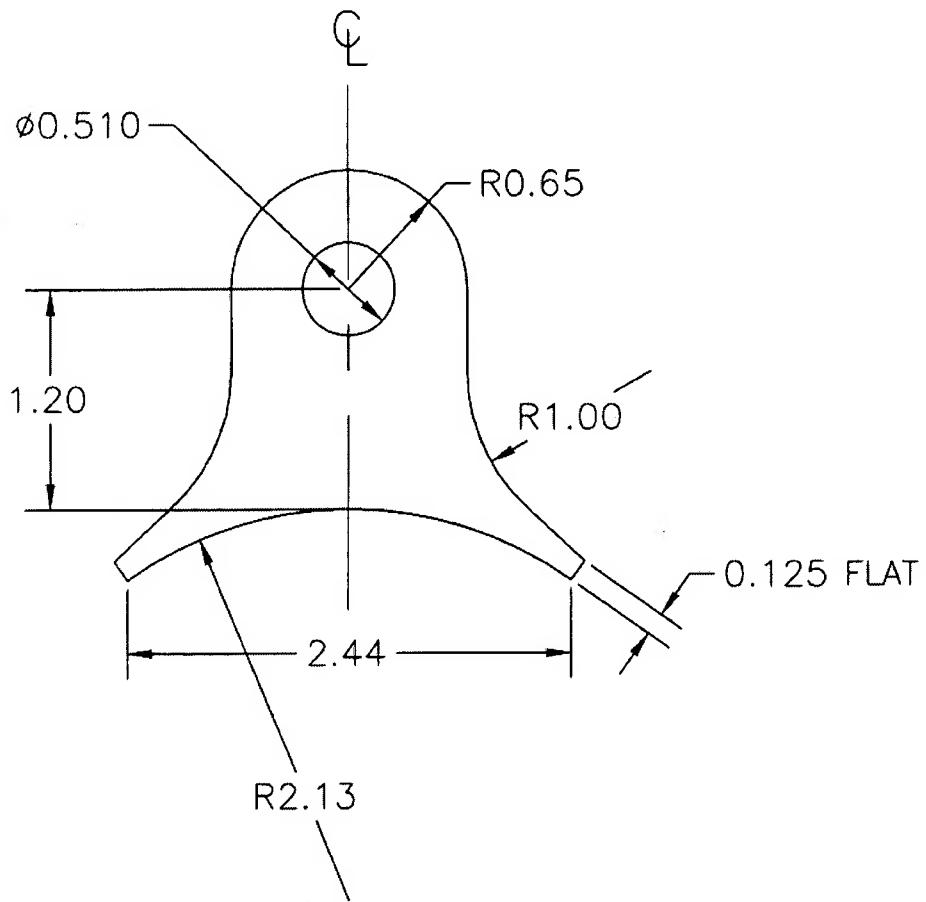
Audited by: JL
Date: 07/06/23

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DSI 9161-011	KJ/JLM <i>✓</i>	<i>✓</i>

DARTDRAFT COPY
DRAFT

DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21	TITLE GHW LUG		SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
48.01.21 DS

BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~
 MATERIAL: ASTM A36 STEEL 0.50 THICK
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 PART IS SYMMETRIC ABOUT CENTER-LINE
 ALL DIMENSIONS ARE IN INCHES

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *32761*